

Work Order ID 141512***141512***

Page 1

Item ID: D3500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle

Start Date: 2/3/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJDate: FEB 08 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3500

C

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.07

Program Batch No. 141512 Double check by: ld 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA641 and inspect p

200DAS
20
9-8916-02-23

110

0.00

110

QC

Quality Control

QC1- Inspection performed by CMM

Memo

0.00

Inspect on CMM as per folio CMMA031.
DWG REV: C
CMM PROG. REV: C

200DAS
20
9-8916-02-24

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.01

200DAS
14
9-8916/02/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 141512

Friday, February 05, 2016 8:08:25 AM

141512

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 2/3/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 2/3/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.01				x20	φ	1600-25	238
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 10:40 FINISH TIME: 11:10 OVEN TEMPERATURE: 300								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

FEB 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		☐ OTHER : _____			

Work Order ID 141512***141512***

Page 3

Friday, February 05, 2016 8:08:25 AM

Item ID: D3500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle

Stop ***NS2***

Start Date: 2/3/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: Sf 406 0.00***160***

Packaging

Memo

0.00

Packaging

20 MLJ 16-02-25

170

QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

0.03

Quality Control

MLJ FEB 26 2016MLJ FEB 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Picklist Print

Friday, February 05, 2016 8:08:28 AM

Page 1

Work Order ID: 141512

141512

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 2/3/2016

Required Date: 2/3/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6102-013		Manufactured	No			100	Each	89.0000	1	20			DAS
D6102-013									**	20			20
Saddle Billet													9-89 16-02-18

Location

Loc Qty

Loc Code

MAT046

89

138664

9

138975

60

139703

20

6
14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

DART AEROSPACE LTD		Work Order:	141512
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.494	.490	.499	.498	.498
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.583	1.5856	1.5822	1.582
J	0.240	0.260		.248	.244	.251	.247	.251
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.5515	.5515	.5535	.5515	.552
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.046	.046	.046	.046	.046
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.1307	1.1324	1.135	1.1315	1.131
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.258	.254	.251	.252	.251
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.251	.249	.250	.249	.250
AG	0.140	0.160		.151	.149	.150	.149	.150
AH	0.140	0.160		.147	.142	.144	.148	.148
AI	0.140	0.160		.144	.144	.143	.146	.146

Accept/Reject

Measured by:	20 S-60	DAS	Date:	16-02-19
Audited by:	14 9-119		Date:	16/02/24
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	141512
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6#	7#	8#	9#	10#
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.500	.499	.500	.496	.4985
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.581	1.5802	1.583	1.582	1.5824
J	0.240	0.260		.250	.251	.248	.248	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.553	.5515	.554	.554	.554
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.046	.046	.046	.046	.046
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.131	1.1336	1.133	1.132	1.1324
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.253	.253	.253	.253	.252
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.248	.250	.249	.250	.250
AG	0.140	0.160		.151	.151	.150	.150	.149
AH	0.140	0.160		.145	.144	.144	.146	.146
AI	0.140	0.160		.144	.145	.145	.145	.144

Accept/Reject

Measured by:	20 DAS	Date:	16-02-22
Audited by:	14	Date:	16/02/24
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	141512
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11 #	12 #	13 #	14 #	15 #
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.4985	.496	.4985	.4995	.4995
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.582	1.5826	1.582	1.5835	1.582
J	0.240	0.260		.249	.249	.248	.249	.248
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.554	.5495	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.046	.046	.046	.046	.046
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.133	1.1326	1.1316	1.133	1.132
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.253	.253	.254	.253	.253
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.249	.250	.249	.251	.249
AG	0.140	0.160		.149	.149	.149	.150	.149
AH	0.140	0.160		.146	.145	.146	.144	.144
AI	0.140	0.160		.144	.142	.146	.146	.146

DAS Accept/Reject

Measured by:	20 9-09	DAS	Date:	16-02-22
Audited by:	14 02-20		Date:	16/02/24
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

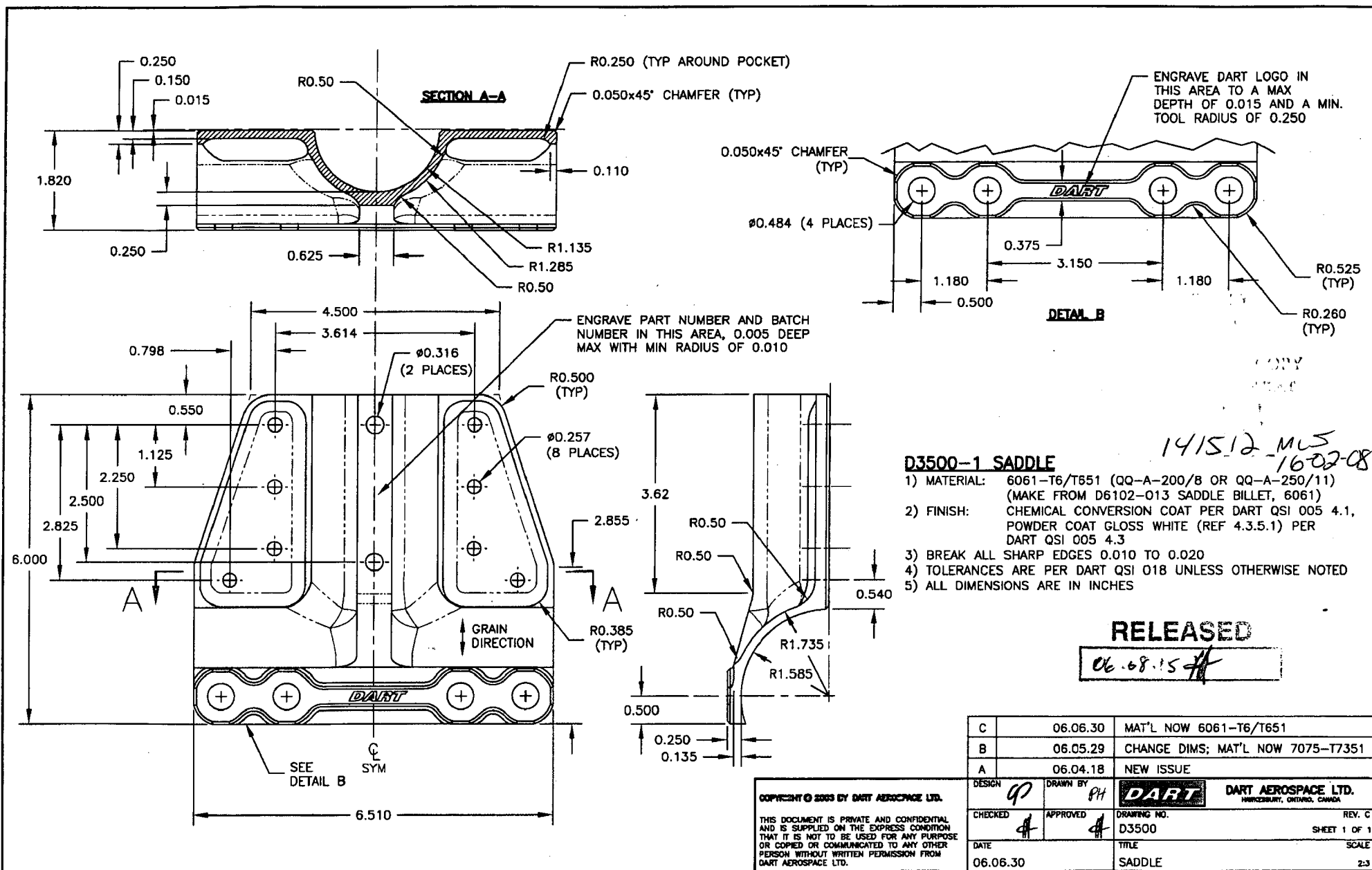
DART AEROSPACE LTD		Work Order:	141512
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16 #	17 #	18 #	19 #	20 #
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.499	.496	.501	.501	.5015
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.5816	1.5824	1.5848	1.582	1.584
J	0.240	0.260		.248	.248	.249	.249	.246
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.550	.551	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.046	.046	.046	.046	.046
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.1316	1.1324	1.1348	1.1324	1.133
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.255	.253	.253	.253	.250
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.249	.249	.252	.249	.247
AG	0.140	0.160		.149	.149	.152	.148	.146
AH	0.140	0.160		.146	.147	.147	.145	.142
AI	0.140	0.160		.147	.146	.145	.146	.143
DAS Accept/Reject								

Measured by:	ZU 9-89	DAS	Date:	16-02-23
Audited by:	14 9-99		Date:	16/02/24
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	





Part Number: D3500-1	Rev: C	- Page 1 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
1	0.2500	+0.0100/-0.0100	0.2520	0.2502	0.2517	0.2505	0.2506
2	0.1500	+0.0100/-0.0100	0.1522	0.1505	0.1513	0.1501	0.1540
3	0.0150	+0.0100/-0.0100	0.0141	0.0123	0.0083	0.0110	0.0101
D4	0.1500	+0.0100/-0.0100	0.1590	0.1590	0.1550	0.1560	0.1550
D5	0.2500	+0.0100/-0.0100	0.2500	0.2500	0.2500	0.2500	0.2500
D6	0.0500	+0.0100/-0.0100	0.0500	0.0500	0.0500	0.0500	0.0500
D7	0.1100	+0.0100/-0.0100	0.1080	0.1100	0.1100	0.1100	0.1100
8	1.1350	+0.0100/-0.0100	1.1315	1.1316	1.1294	1.1300	1.1295
D9	0.5000	+0.0300/-0.0300	0.5000	0.5000	0.5000	0.5000	0.5000
D10	0.6250	+0.0100/-0.0100	0.6350	0.6350	0.6350	0.6350	0.6350
D11	0.2500	+0.0100/-0.0100	0.2570	0.2530	0.2530	0.2530	0.2530
12	1.8200	+0.0100/-0.0100	1.8200	1.8179	1.8181	1.8167	1.8184
13	0.4840	+0.0060/-0.0010	0.4850	0.4853	0.4852	0.4853	0.4848
14	1.1800	+0.0050/-0.0050	1.1796	1.1806	1.1794	1.1794	1.1805
15	0.5000	+0.0100/-0.0100	0.4965	0.4930	0.5016	0.4997	0.5005
D16	0.3750	+0.0100/-0.0100	0.3750	0.3750	0.3750	0.3750	0.3750
17	3.1500	+0.0050/-0.0050	3.1497	3.1495	3.1499	3.1495	3.1494
18	1.1800	+0.0050/-0.0050	1.1794	1.1793	1.1792	1.1796	1.1798
19	0.5250	+0.0100/-0.0100	0.5257	0.5241	0.5251	0.5235	0.5259
20	0.5400	+0.0100/-0.0100	0.5402	0.5381	0.5325	0.5366	0.5358
D21	0.1500	+0.0100/-0.0100	0.1560	0.1550	0.1550	0.1560	0.1560
22	1.5850	+0.0100/-0.0100	1.5832	1.5853	1.5870	1.5854	1.5824
23	0.2500	+0.0100/-0.0100	0.2488	0.2478	0.2532	0.2510	0.2540
24	0.5000	+0.0100/-0.0100	0.5008	0.5007	0.5010	0.4990	0.5008
D25	3.6200	+0.0300/-0.0300	3.6200	3.6200	3.6200	3.6200	3.6200
26	0.7980	+0.0050/-0.0050	0.7991	0.7968	0.7994	0.7972	0.7993
27	3.6140	+0.0050/-0.0050	3.6114	3.6139	3.6137	3.6135	3.6137
28	0.3160	+0.0050/-0.0010	0.3159	0.3157	0.3158	0.3158	0.3156
29	0.2570	+0.0050/-0.0010	0.2582	0.2573	0.2581	0.2578	0.2573
30	6.5100	+0.0100/-0.0100	6.5100	6.5091	6.5111	6.5106	6.5112
31	6.0000	+0.0100/-0.0100	5.9996	6.0016	6.0068	6.0039	6.0044
32	2.8250	+0.0050/-0.0050	2.8274	2.8280	2.8241	2.8254	2.8260

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date:



Part Number: D3500-1	Rev: C	- Page 2 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
33	2.5000	+0.0050/-0.0050	2.5010	2.4994	2.4991	2.5008	2.4998
34	2.2500	+0.0050/-0.0050	2.2489	2.2508	2.2477	2.2490	2.2492
35	1.1250	+0.0050/-0.0050	1.1249	1.1249	1.1237	1.1252	1.1251
36	0.5500	+0.0100/-0.0100	0.5496	0.5511	0.5582	0.5536	0.5550

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date:



Part Number: D3500-1	Rev: C	- Page 1 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
1	0.2500	+0.0100/-0.0100	0.2501	0.2519	0.2511	0.2519	0.2503
2	0.1500	+0.0100/-0.0100	0.1533	0.1520	0.1510	0.1535	0.1516
3	0.0150	+0.0100/-0.0100	0.0107	0.0088	0.0091	0.0090	0.0103
D4	0.1500	+0.0100/-0.0100	0.1560	0.1570	0.1580	0.1570	0.1570
D5	0.2500	+0.0100/-0.0100	0.2500	0.2500	0.2500	0.2500	0.2500
D6	0.0500	+0.0100/-0.0100	0.0500	0.0500	0.0500	0.0500	0.0500
D7	0.1100	+0.0100/-0.0100	0.1100	0.1100	0.1100	0.1100	0.1100
8	1.1350	+0.0100/-0.0100	1.1299	1.1298	1.1298	1.1298	1.1299
D9	0.5000	+0.0300/-0.0300	0.5000	0.5000	0.5000	0.5000	0.5000
D10	0.6250	+0.0100/-0.0100	0.6350	0.6350	0.6350	0.6350	0.6350
D11	0.2500	+0.0100/-0.0100	0.2530	0.2530	0.2530	0.2530	0.2530
12	1.8200	+0.0100/-0.0100	1.8173	1.8200	1.8186	1.8189	1.8165
13	0.4840	+0.0060/-0.0010	0.4852	0.4851	0.4851	0.4849	0.4853
14	1.1800	+0.0050/-0.0050	1.1799	1.1794	1.1799	1.1796	1.1795
15	0.5000	+0.0100/-0.0100	0.5015	0.4999	0.4994	0.4981	0.5004
D16	0.3750	+0.0100/-0.0100	0.3750	0.3750	0.3750	0.3750	0.3750
17	3.1500	+0.0050/-0.0050	3.1491	3.1495	3.1496	3.1497	3.1495
18	1.1800	+0.0050/-0.0050	1.1799	1.1796	1.1798	1.1792	1.1801
19	0.5250	+0.0100/-0.0100	0.5260	0.5242	0.5244	0.5248	0.5242
20	0.5400	+0.0100/-0.0100	0.5375	0.5387	0.5368	0.5362	0.5330
D21	0.1500	+0.0100/-0.0100	0.1560	0.1560	0.1560	0.1560	0.1560
22	1.5850	+0.0100/-0.0100	1.5811	1.5798	1.5860	1.5855	1.5860
23	0.2500	+0.0100/-0.0100	0.2516	0.2529	0.2493	0.2499	0.2506
24	0.5000	+0.0100/-0.0100	0.5014	0.5015	0.5014	0.5012	0.5016
D25	3.6200	+0.0300/-0.0300	3.6200	3.6200	3.6200	3.6200	3.6200
26	0.7980	+0.0050/-0.0050	0.7993	0.8007	0.7976	0.7935	0.7966
27	3.6140	+0.0050/-0.0050	3.6129	3.6117	3.6133	3.6148	3.6125
28	0.3160	+0.0050/-0.0010	0.3158	0.3156	0.3155	0.3157	0.3159
29	0.2570	+0.0050/-0.0010	0.2580	0.2578	0.2578	0.2579	0.2578
30	6.5100	+0.0100/-0.0100	6.5115	6.5114	6.5112	6.5107	6.5113
31	6.0000	+0.0100/-0.0100	6.0027	6.0015	6.0034	6.0037	6.0055
32	2.8250	+0.0050/-0.0050	2.8228	2.8255	2.8237	2.8281	2.8271

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date:



Part Number: D3500-1	Rev: C	- Page 2 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
33	2.5000	+0.0050/-0.0050	2.4993	2.4999	2.4992	2.5003	2.5004
34	2.2500	+0.0050/-0.0050	2.2472	2.2497	2.2492	2.2518	2.2507
35	1.1250	+0.0050/-0.0050	1.1230	1.1249	1.1228	1.1260	1.1250
36	0.5500	+0.0100/-0.0100	0.5560	0.5529	0.5556	0.5526	0.5558

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date:



Part Number: D3500-1	Rev: C	- Page 1 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_11 Actual	No. Piece_12 Actual	No. Piece_13 Actual	No. Piece_14 Actual	No. Piece_15 Actual
1	0.2500	+0.0100/-0.0100	0.2506	0.2513	0.2503	0.2522	0.2507
2	0.1500	+0.0100/-0.0100	0.1505	0.1515	0.1514	0.1519	0.1504
3	0.0150	+0.0100/-0.0100	0.0103	0.0099	0.0107	0.0092	0.0105
D4	0.1500	+0.0100/-0.0100	0.1560	0.1560	0.1570	0.1560	0.1570
D5	0.2500	+0.0100/-0.0100	0.2500	0.2500	0.2500	0.2500	0.2500
D6	0.0500	+0.0100/-0.0100	0.0500	0.0500	0.0500	0.0500	0.0500
D7	0.1100	+0.0100/-0.0100	0.1100	0.1100	0.1100	0.1100	0.1100
8	1.1350	+0.0100/-0.0100	1.1300	1.1301	1.1301	1.1302	1.1302
D9	0.5000	+0.0300/-0.0300	0.5000	0.5000	0.5000	0.5000	0.5000
D10	0.6250	+0.0100/-0.0100	0.6350	0.6350	0.6350	0.6350	0.6250
D11	0.2500	+0.0100/-0.0100	0.2530	0.2530	0.2530	0.2540	0.2530
12	1.8200	+0.0100/-0.0100	1.8173	1.8177	1.8174	1.8187	1.8172
13	0.4840	+0.0060/-0.0010	0.4851	0.4853	0.4855	0.4857	0.4851
14	1.1800	+0.0050/-0.0050	1.1807	1.1794	1.1799	1.1794	1.1791
15	0.5000	+0.0100/-0.0100	0.5003	0.4972	0.5010	0.4996	0.4981
D16	0.3750	+0.0100/-0.0100	0.3750	0.3750	0.3750	0.3750	0.3750
17	3.1500	+0.0050/-0.0050	3.1492	3.1495	3.1495	3.1492	3.1499
18	1.1800	+0.0050/-0.0050	1.1800	1.1799	1.1801	1.1804	1.1796
19	0.5250	+0.0100/-0.0100	0.5241	0.5249	0.5248	0.5247	0.5242
20	0.5400	+0.0100/-0.0100	0.5371	0.5342	0.5404	0.5403	0.5395
D21	0.1500	+0.0100/-0.0100	0.1550	0.1550	0.1570	0.1560	0.1560
22	1.5850	+0.0100/-0.0100	1.5841	1.5846	1.5843	1.5840	1.5840
23	0.2500	+0.0100/-0.0100	0.2498	0.2501	0.2493	0.2499	0.2503
24	0.5000	+0.0100/-0.0100	0.5011	0.5011	0.5007	0.5010	0.5009
D25	3.6200	+0.0300/-0.0300	3.6200	3.6200	3.6200	3.6200	3.6200
26	0.7980	+0.0050/-0.0050	0.7977	0.7972	0.7975	0.7957	0.7978
27	3.6140	+0.0050/-0.0050	3.6114	3.6131	3.6128	3.6139	3.6134
28	0.3160	+0.0050/-0.0010	0.3159	0.3159	0.3160	0.3159	0.3159
29	0.2570	+0.0050/-0.0010	0.2579	0.2580	0.2581	0.2578	0.2579
30	6.5100	+0.0100/-0.0100	6.5110	6.5093	6.5108	6.5109	6.5106
31	6.0000	+0.0100/-0.0100	6.0034	5.9998	5.9993	6.0007	6.0004
32	2.8250	+0.0050/-0.0050	2.8259	2.8272	2.8260	2.8253	2.8270

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date:



Part Number: D3500-1	Rev: C	- Page 2 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_11 Actual	No. Piece_12 Actual	No. Piece_13 Actual	No. Piece_14 Actual	No. Piece_15 Actual
33	2.5000	+0.0050/-0.0050	2.5000	2.5008	2.5011	2.4990	2.5001
34	2.2500	+0.0050/-0.0050	2.2502	2.2520	2.2503	2.2494	2.2509
35	1.1250	+0.0050/-0.0050	1.1249	1.1248	1.1250	1.1254	1.1248
36	0.5500	+0.0100/-0.0100	0.5532	0.5487	0.5499	0.5510	0.5500

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date:



Part Number: D3500-1	Rev: C	- Page 1 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_16 Actual	No. Piece_17 Actual	No. Piece_18 Actual	No. Piece_19 Actual	No. Piece_20 Actual
1	0.2500	+0.0100/-0.0100	0.2509	0.2508	0.2530	0.2506	0.2490
2	0.1500	+0.0100/-0.0100	0.1506	0.1506	0.1530	0.1501	0.1491
3	0.0150	+0.0100/-0.0100	0.0115	0.0103	0.0080	0.0109	0.0096
D4	0.1500	+0.0100/-0.0100	0.1560	0.1560	0.1570	0.1560	0.1530
D5	0.2500	+0.0100/-0.0100	0.2500	0.2500	0.2500	0.2500	0.2500
D6	0.0500	+0.0100/-0.0100	0.0500	0.0500	0.0500	0.0500	0.0500
D7	0.1100	+0.0100/-0.0100	0.1100	0.1100	0.1100	0.1100	0.1100
8	1.1350	+0.0100/-0.0100	1.1302	1.1299	1.1301	1.1303	1.1309
D9	0.5000	+0.0300/-0.0300	0.5000	0.5000	0.5000	0.5000	0.5000
D10	0.6250	+0.0100/-0.0100	0.6350	0.6350	0.6350	0.6350	0.6350
D11	0.2500	+0.0100/-0.0100	0.2540	0.2530	0.2520	0.2530	0.2500
12	1.8200	+0.0100/-0.0100	1.8169	1.8173	1.8205	1.8173	1.8158
13	0.4840	+0.0060/-0.0010	0.4855	0.4850	0.4852	0.4851	0.4851
14	1.1800	+0.0050/-0.0050	1.1797	1.1793	1.1798	1.1801	1.1802
15	0.5000	+0.0100/-0.0100	0.4986	0.4981	0.4979	0.4986	0.4974
D16	0.3750	+0.0100/-0.0100	0.3750	0.3750	0.3750	0.3750	0.3750
17	3.1500	+0.0050/-0.0050	3.1499	3.1501	3.1494	3.1491	3.1496
18	1.1800	+0.0050/-0.0050	1.1791	1.1799	1.1797	1.1794	1.1798
19	0.5250	+0.0100/-0.0100	0.5246	0.5246	0.5234	0.5218	0.5234
20	0.5400	+0.0100/-0.0100	0.5407	0.5389	0.5410	0.5401	0.5391
D21	0.1500	+0.0100/-0.0100	0.1570	0.1550	0.1570	0.1560	0.1530
22	1.5850	+0.0100/-0.0100	1.5845	1.5853	1.5839	1.5837	1.5844
23	0.2500	+0.0100/-0.0100	0.2502	0.2507	0.2509	0.2503	0.2470
24	0.5000	+0.0100/-0.0100	0.5007	0.5012	0.5012	0.5014	0.5013
D25	3.6200	+0.0300/-0.0300	3.6200	3.6200	3.6200	3.6200	3.6200
26	0.7980	+0.0050/-0.0050	0.7979	0.7995	0.7990	0.7970	0.7964
27	3.6140	+0.0050/-0.0050	3.6137	3.6131	3.6131	3.6127	3.6127
28	0.3160	+0.0050/-0.0010	0.3157	0.3152	0.3160	0.3156	0.3159
29	0.2570	+0.0050/-0.0010	0.2581	0.2578	0.2575	0.2581	0.2584
30	6.5100	+0.0100/-0.0100	6.5108	6.5109	6.5106	6.5109	6.5107
31	6.0000	+0.0100/-0.0100	6.0003	6.0013	6.0007	6.0002	6.0003
32	2.8250	+0.0050/-0.0050	2.8253	2.8248	2.8248	2.8266	2.8288

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date:



Part Number: D3500-1	Rev: C	- Page 2 -
Description: SADDLE	Inspection Dwg: D3500	Work Order: 141512

Item Ref.	Nominal	Tolerance	No. Piece_16 Actual	No. Piece_17 Actual	No. Piece_18 Actual	No. Piece_19 Actual	No. Piece_20 Actual
33	2.5000	+0.0050/-0.0050	2.5003	2.5006	2.5003	2.5007	2.5007
34	2.2500	+0.0050/-0.0050	2.2492	2.2498	2.2509	2.2515	2.2522
35	1.1250	+0.0050/-0.0050	1.1248	1.1247	1.1249	1.1252	1.1279
36	0.5500	+0.0100/-0.0100	0.5502	0.5521	0.5504	0.5497	0.5486

Measured by:
Mathieu Lamarche

Date:
2016-2-24

Audited by:

Date: